

Ship 17/05

Work Order ID 58506

May 7, 2010 3:04:34 PM



Page 1

Item ID: D3935-4

Accept



Setup Start



Revision ID:

Item Name: Pylon Wall Protector, RH

Stop



Start Date: 07/05/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 24/05/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

RP

Date:

10-5-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3935

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3935

Dwg Rev: *B*

Prog Rev: *B*

2- Deburr if necessary

B10-5-11

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-5-11

Pro 10/05/12

(2)

| W/O: | | | WORK ORDER CHANGES | | | | | |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries




Work Order ID 58506

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Page 2

| | | | | | | |
|----------------|--------------------------|------------|---|---|---------------|---|
| Item ID: | D3935-4 | Accept |  | Setup | Start |  |
| Revision ID: | | | | | | |
| Item Name: | Pylon Wall Protector, RH | | | | Stop |  |
| Start Date: | 07/05/2010 | Start Qty: | 2.00 |  | Cust Item ID: | |
| Required Date: | 24/05/2010 | Req'd Qty: | 2.00 |  | Customer: | |
| Reference: | | | | | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|---|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start |  |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop |  |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 120  QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | Sudastio | | | (+2) | | | |
| 130  Packaging Packaging | Identify as per dwg & Stock Location: Memo | 0.00 0.00 | PPR 58050 | | | | | | 10/05/12 (2) |
| 140  QC Quality Control | QC2- Inspect parts Off machine FAL/FAID Memo | 0.00 0.00 | QC 21 N/A | | | | | | 10/05/13 (2) |

10/05/13 (2)

10-5-12 (2)

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NOTE: Date & initial all entries

Picklist Print

May 7, 2010 3:04:40 PM

Page 1

Work Order ID: 58506

Parent Item: D3935-4

Parent Item Name: Pylon Wall Protector, RH

Comments: IPP RevA: New issue DD verified by:EC

Start Date: 07/05/2010

Required Date: 24/05/2010

Start Qty: 2.00

Required Qty: 2.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|---------------|----------------|--------|
| MLEXS.125-F60029-04 GE PLASTICS LEXAN SHEET | | Purchased | No | | | 100 | sf | 2,595.865 | 8.048 | 16.09 | | |

Location

Loc Qty

Loc Code

MAT

2595.8658

111710

64

112585

184.333

114032

2347.5328

114032

1810-5-11

②

| W/O: | | | WORK ORDER CHANGES | | | | | |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

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|---|---------------|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 58506 |
| Description: Pylon Wall Protector, RH. | | Part Number: | D3935-4 |
| Inspection Dwg: D3935 | Rev: B | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 5.68 | +/-0.030 | 5.68 | ✓ | | | |
| 12.68 | +/-0.030 | 12.68 | ✓ | | | |
| 18.75 | +/-0.030 | 18.75 | ✓ | | | |
| 19.00 | +/-0.030 | 19.00 | ✓ | | | |
| 20.25 | +/-0.030 | 20.25 | ✓ | | | |
| 22.75 | +/-0.030 | 22.75 | ✓ | | | |
| 23.73 | +/-0.030 | 23.73 | ✓ | | | |
| 28.63 | +/-0.030 | 28.63 | ✓ | | | |
| 32.75 | +/-0.030 | 32.75 | ✓ | | | |
| 1.00 | +/-0.030 | 1.00 | ✓ | | | |
| 3.50 | +/-0.030 | 3.50 | ✓ | | | |
| 9.00 | +/-0.030 | 9.00 | ✓ | | | |
| 14.70 | +/-0.030 | 14.70 | ✓ | | | |
| 16.20 | +/-0.030 | 16.20 | ✓ | | | |
| 33.40 | +/-0.030 | 33.380 | ✓ | | | |
| 34.25 | +/-0.030 | 34.25 | ✓ | | | |
| 34.60 | +/-0.030 | 34.60 | ✓ | | | |
| 34.72 | +/-0.030 | 34.72 | ✓ | | | |
| 22.85 | +/-0.030 | 22.85 | ✓ | | | |
| 19.15 | +/-0.030 | 19.15 | ✓ | | | |
| 35.39 | +/-0.030 | 35.39 | ✓ | | | |
| 0.125 | +/-0.010 | 0.130 | ✓ | | | |
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|------------------------|-----------------------|----------------------------|-----|
| Measured by: RB | Audited by: S | Prototype Approval: | N/A |
| Date: 10-5-11 | Date: 10/05/12 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 09.11.17 | New Issue | KJ | |

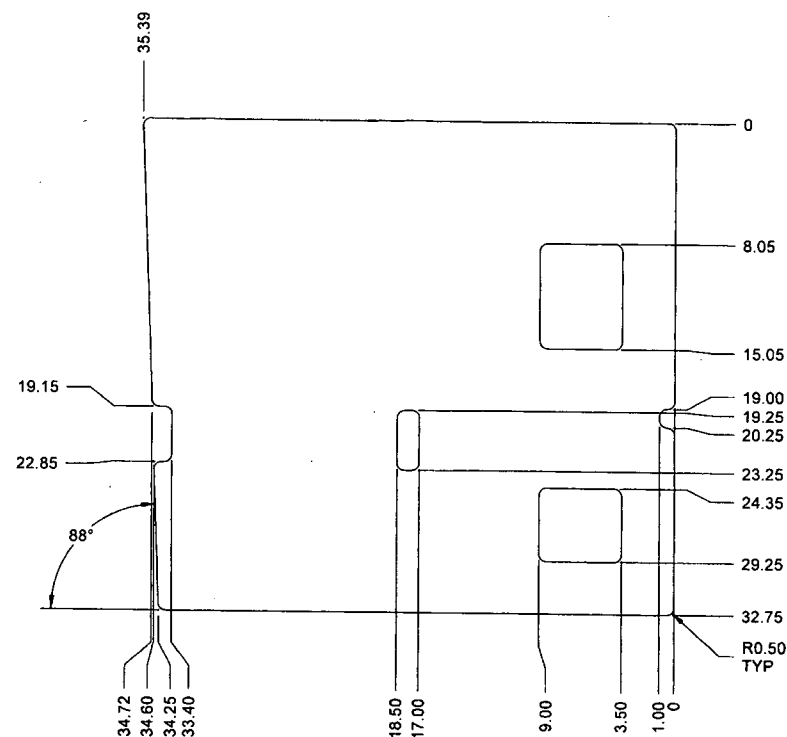
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58509

2010-5-10
RELEASED
2009-10-22
MD

D3935-1 PYLON WALL PROTECTOR, LH
(TEXTURED SIDE SHOWN)

NOTES:

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF. DART SPEC MLEXS. 125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 5.79 LBS
- 8) CHECK PER TEMPLATE DT8922

| B | ADD-3, -4 (SHEET 3, 4) | HS | 09.08.19 |
|------------|------------------------|----|----------|
| A | NEW ISSUE | HS | 09.04.21 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 09.08.19 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3935** REV. B
SHEET 1 OF 4
TITLE **PYLON PROTECTOR** SCALE NTS

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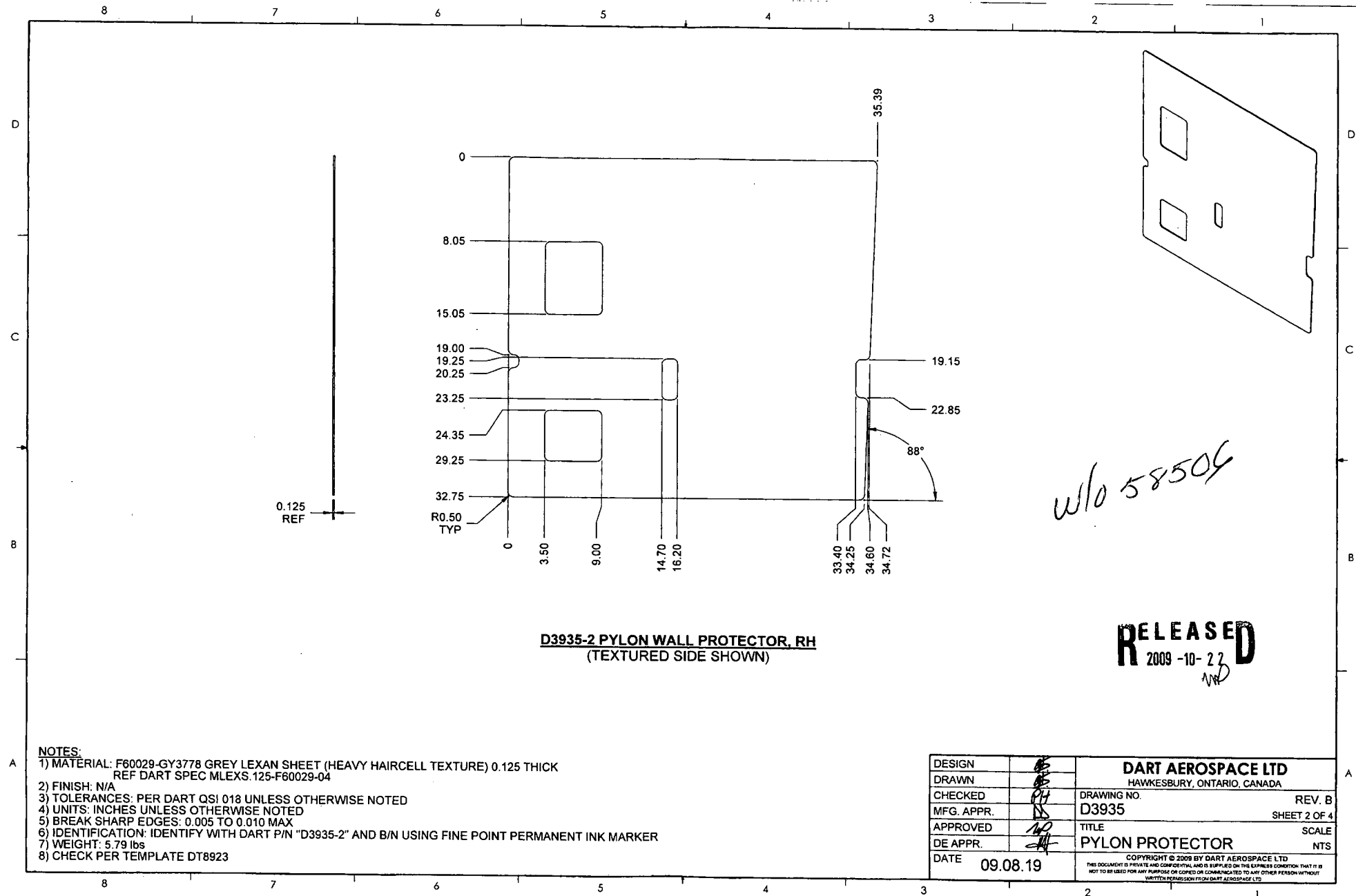
| W/O: | | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries



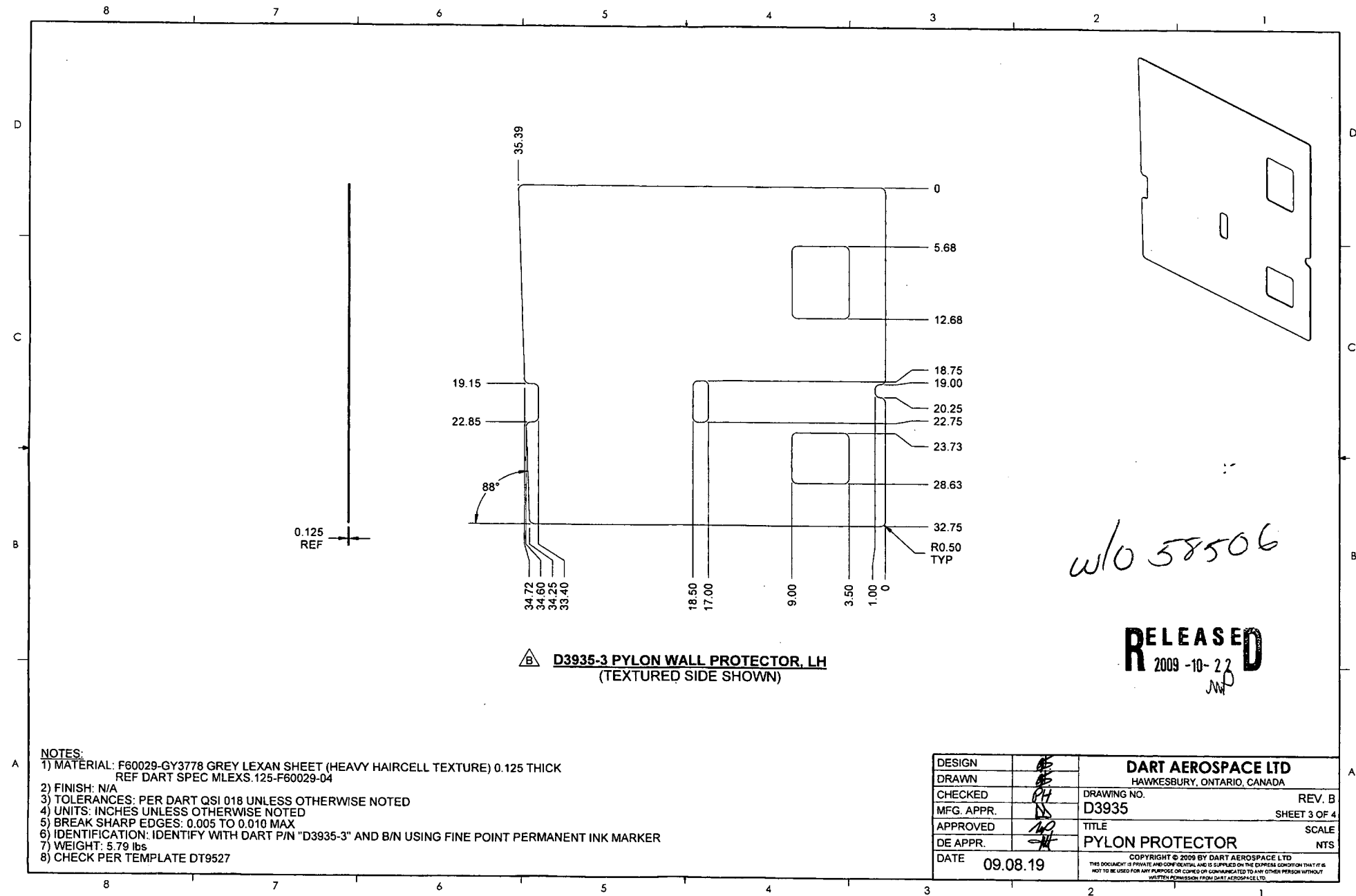
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NOTE: Date & initial all entries



w/o 58506

RELEASED
2009 -10-23
NW

NOTES:

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REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 5.79 lbs
- 8) CHECK PER TEMPLATE DT9527

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3935 | SHEET 3 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | PYLON PROTECTOR | NTS |
| DATE | 09.08.19 | <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

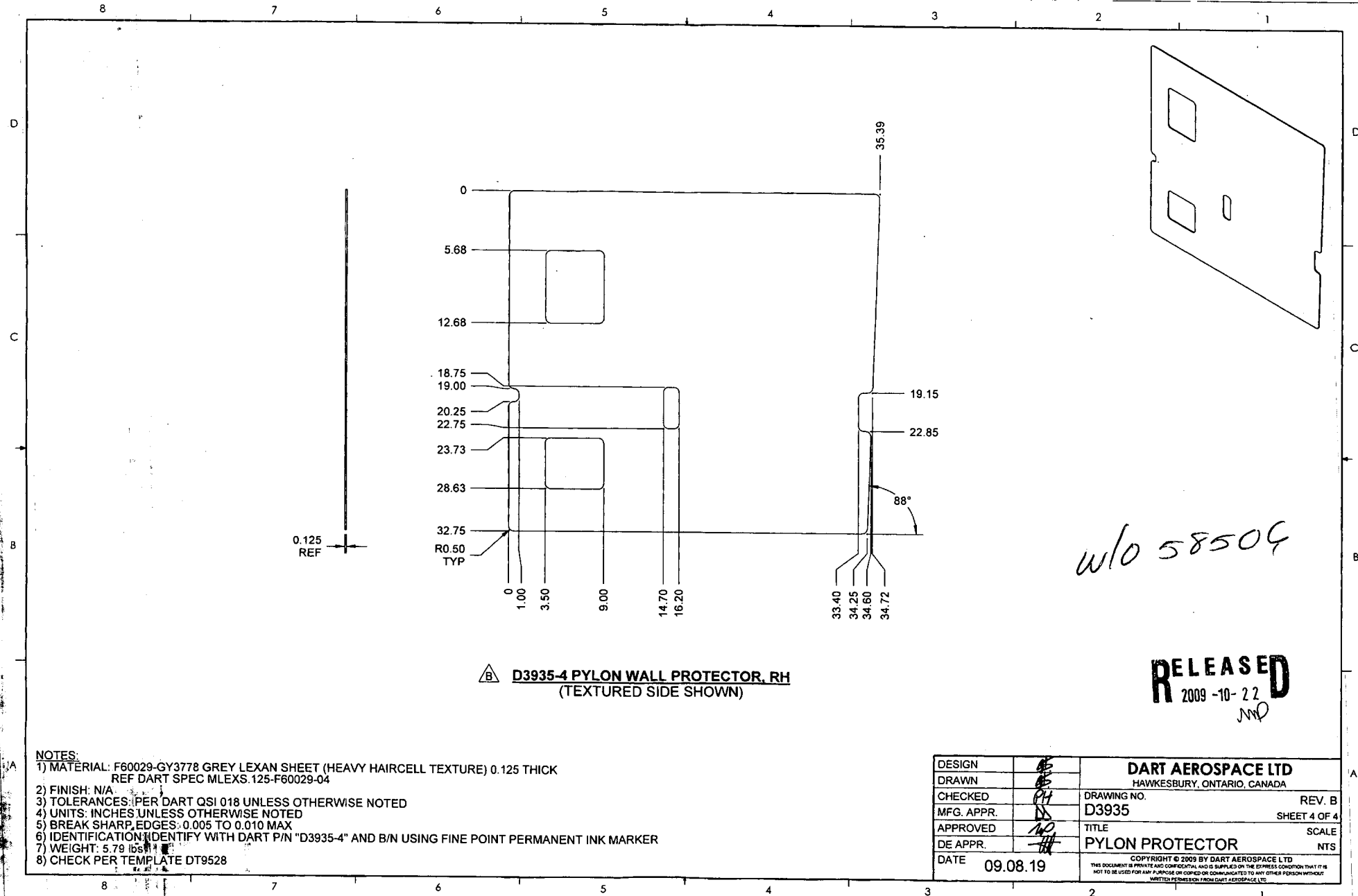
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